

Work Order ID 70349

Friday, June 03, 2011 10:15:40 AM



Page 1

Item ID: D4021-5

Accept

Revision ID:

Item Name: Blanking Plate

Start Date: 6/3/2011 Start Qty: 12.00

Required Date: 6/7/2011 Req'd Qty: 12.00



Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

QC:

Date:

SPC (Y/N):

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw Nbr

Revision Nbr

D4021

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4021

Prog Rev: *B*

Dwg Rev: *B*

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Date:

Date:

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

B11-6-6

52

B11-6-6

Work Order ID 70349

Friday, June 03, 2011 10:15:40 AM

Page 2

Item ID: D4021-5

Revision ID:

Item Name: Blanking Plate

Start Date: 6/3/2011 Start Qty: 12.00

Required Date: 6/7/2011 Req'd Qty: 12.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

135

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



0.00
0.00
Sulog 6/06

0.00
0.00
Start Time: 10:10
Temp: 400°F
Finish Time: 10:40

count
x28

22 x 4 m-11/06/13

22 x 4 m-11/06/13

Work Order ID 70349

Friday, June 03, 2011 10:15:40 AM



Page 3

Item ID: D4021-5

Accept

Revision ID:

Item Name: Blanking Plate

Start Date: 6/3/2011 Start Qty: 12.00

Required Date: 6/7/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

QC:

Date:

SPC (Y/N):

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

140

Identify as per dwg & Stock Location: G.A

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Handwritten: 5/11/06/13 (22x)

Handwritten: 11/6/14
11-06-13 (22)

Picklist Print

Friday, June 03, 2011 10:15:37 AM

Work Order ID: 70349

Parent Item: D4021-5

Parent Item Name: Blanking Plate



Page 1

T

Start Date: 6/3/2011

Required Date: 6/7/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg REV.A DD 10.02.22 verified by:EC
DD 10.04.20 verified by:EC
IPP Rev:B as per dwg revB
IPP Rev:C as per dwg revB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	122.6000	0.0622	0.785684			



304/316 Sheet .063



B11-6-6

Location

MAT020

117275

117653

Loc Qty

122.6

7.8

114.8

Loc Code

117275

63

DART AEROSPACE LTD		Work Order:	10549
Description: Blanking Plate		Part Number:	D4021-5
Inspection Dwg: D4021 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X

[illegible]

Measured by:	IB
Date:	11-6-6

8

7

6

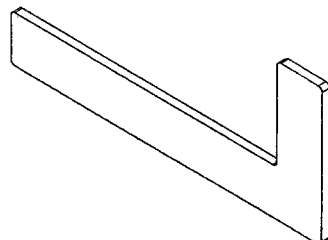
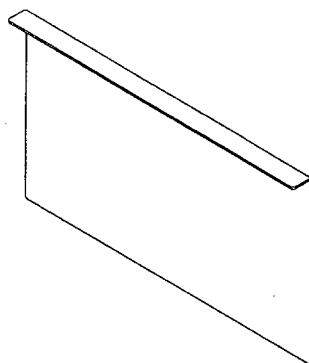
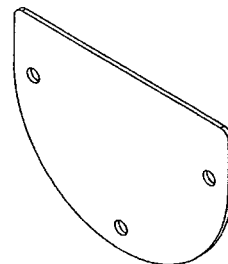
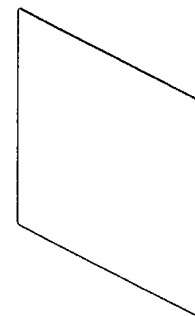
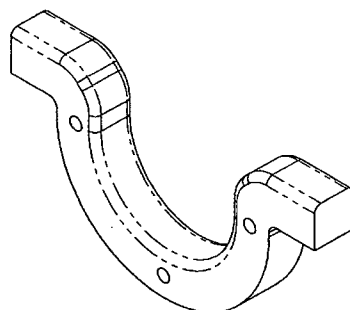
5

4

3

2

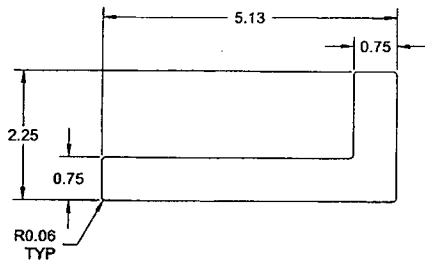
1

**D4021-1 HANDLE PLATE****D4021-3 DATA PLATE****D4021-5 BLANKING PLATE****D4021-11 INSTRUCTIONS PLATE****D4021-7 HOOP****D4021-9 BUSHING**

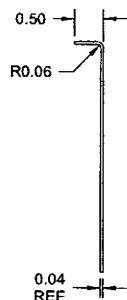
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2010-04-14
MD

B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

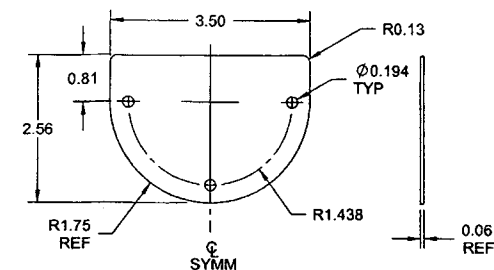
WLO 70349



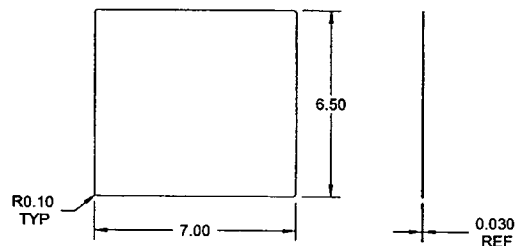
D4021-1 HANDLE PLATE



D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE

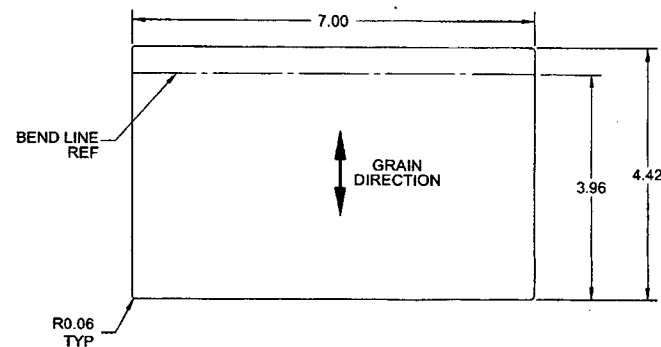


D4021-11 INSTRUCTIONS PLATE

NOTES:





- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

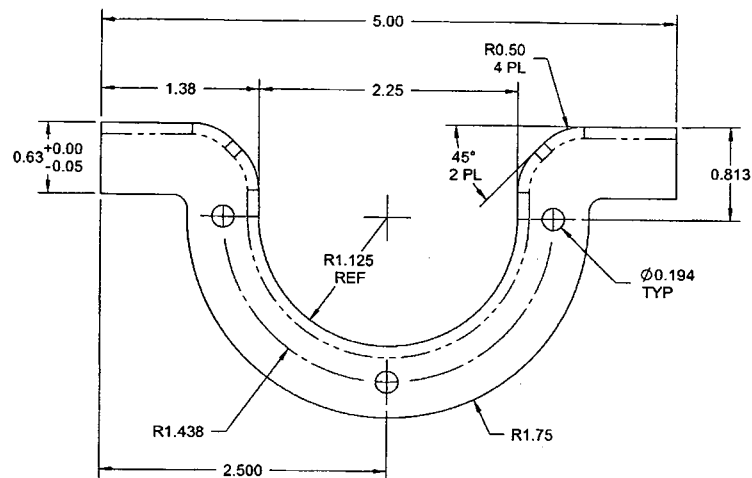
- 2) FINISH: -1/-3/-11: NONE
- 5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs -3: 0.35 lbs
-5: 0.14 lbs -11: 0.39 lbs



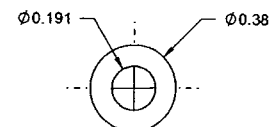
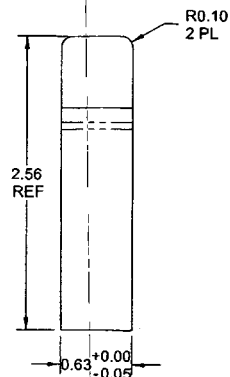
D4021-3F DATA PLATE
FLAT PATTERN

RELEASED
2010-04-14
NP

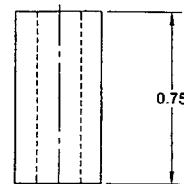
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPI	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
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D4021-7 HOOP



D4021-9 BUSHING



NOTES:





1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

RELEASED
2010-04-14
NR

70349

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
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